

DART
AEROSPACE

Container No: S186777



Part: C3
Job No: 194630
Serial No/Batch: S186777
Revision: 2
Inspector:
Exp Date:
Instructions:

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CANADA
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Date: 06/04/19

	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
	Packaging 3 - 27 - B4B				
	Packaging 3 - 28 - B4B				
	Packaging 3 - 29 - B4B				
	Packaging 3 - 30 - B4B				
	Packaging 3 - 31 - B4B				
	Packaging 3 - 32 - B4B				
	Packaging 3 - 33 - B4B				
	Packaging 3 - 34 - B4B				
	Packaging 3 - 35 - B4B				
Packaging 3 - 36 - B4B	DAS				
140 QC 21 - SA	1 pcs	6/21/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89 JUL 0 5 2019
				QC 21 - SA - 53	
Part Op 95 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- Descriptions: ASSEMBLE AS PER DWG 100 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS PER DWG 110 - QC5- Inspect part completeness to step on W/O) 120 - (Document Control)- Photocopy blue file OM & OOPM-C3 Rev 4 130 - Identify as per dwg & Stock Location: _____)Identify and Stock 140 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	S110495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	S189728
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	S058851
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	S074909
8183K8	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	S118247
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	S157301-3
AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	S157429-3
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	S068641
C2-1-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B	S157074
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S068051
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B	S061528
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B	S163207 S177832
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B	S180410
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B	S029245
C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S173563
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B	S168898
C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	S116487
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B	S120798
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B	S111642
C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B	S083629
C2-3-6	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S178019
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B	S072964
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	S070352
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S182333
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S094886 S117910
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S080193
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S029266
C3-12-4	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	S100620
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S100174 S100174
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B	S157956
C3-12-7	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S029270
C3-12-8	KEEPER	1 pcs (1 ea)	100-External Load - 2 - B4B	S029271
C3-12-9	Spring, Keeper	1 pcs (1 ea)	100-External Load - 2 - B4B	S089547
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S175253
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B	S118503
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-External Load - 2 - B4B	S183330
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B	S048390
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	S128685
C3-4-1	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S180767
C3-4-4A	C3 Load Beam Assy	1 pcs (1 ea)	100-External Load - 2 - B4B	S184524 S179604
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	S186739
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B	S120071
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B	S137893
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B	S180680
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B	S153419
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S029289
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B	S029288 S089524
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B	S176126
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B	S075144
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B	S119541
MS21083N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B	S142051
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	S180294
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	S078256
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	
NAS1149F0332P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	S103666-1
NAS1149F0363P	Washer	1 Ea (1 ea)	100-External Load - 2 - B4B	S027738
NAS1149F0463P	Washer	8 Ea (8 ea)	100-External Load - 2 - B4B	S097088-4
NAS1149F0632P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	S137711

7856K75 SHRINK TUBE 6" S190246

GREASE AEROSHELL 20-7 (M138964)

LOCTITE 620 (S166705)

SAF-T-EZE (M128063)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	192	0
	188-FSCS-832-5/8	4	107	0
100-External Load - 2 - B4B	2595K22	1	35	0
	32446	2	704	0
	8183K6	1	34	0
	AN4-16A	3	348	0
	AN4-17A	1	460	0
	AN6-15A	1	19	0
	C2-1-1	1	8	0
	C2-10-1	1	74	0
	C2-11-2	2	56	0
	C2-3-1	2	70	0
	C2-3-10	1	3	0
	C2-3-11	1	26	0
	C2-3-2	1	27	0
	C2-3-2-1	2	94	0
	C2-3-3	1	50	0
	C2-3-3-1	1	24	0
	C2-3-5	2	67	0
	C2-3-6	1	11	0
	C2-3-8	2	50	0
	C2-5-1	1	12	0
	C3-10-2	1	24	0
	C3-11-1	1	2	0
	C3-12-1	2	29	0
	C3-12-2	1	27	0
	C3-12-3	1	8	0
	C3-12-4	1	32	0
	C3-12-5	1	7	0
	C3-12-6	2	50	0
	C3-13-1	2	36	0
	C3-13-4	1	7	0
	C3-13-5	1	101	0
	C3-2-1	1	21	0
	C3-3-4	2	22	0
	C3-3-4-1	4	120	0
	C3-3-7	1	20	0
	C3-3-9	1	59	0
	C3-4-1	2	1	0
	C3-4-4A	1	9	0
	C3-7-1	1	12	0
	C3-7-2	2	44	0
	C3-8-2	1	12	0
	C3-8-4	1	10	0
	C3-8-5	1	15	0
	C3-9-1	1	18	0
	C3-9-2	1	38	0
	EL-PLUG-M	1	55	0
	M27500-16TG2T14	1	49	0
	MS21044N4	4	116	0
	MS21083N3	2	122	0
	MS21083N6	1	9	0
	MS35266-63	2	28	0
	NAS1149F0332P	2	5,135	0
	NAS1149F0363P	1	437	0
	NAS1149F0463P	8	466	0
	NAS1149F0632P	2	387	0
Part Specifications				
Specifications could not be found.				

Plex 5/6/19 3:53 PM Dart.Renwick.Jennifer

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: <u>194630</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering ☒ Water Jet ☐ Supplier Quality ☐	
Part No. <u>C3 Rev. 2</u>		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube Machining Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐			
Date: <u>July 3, 2019</u>		Sequence #:		QTY Affected:		MRA (OSI042)		Completed By <u>A. Paray</u>	
Description Work Order Deviation		Disposition				QC / QA Coordinator		Lead hand / Supervisor	
Permissible to use 6" of Heat shrink P/N McMaster # 7856K75 for wire connection protection.		This deviation is acceptable. The fit, form, and function is as originally intended.							
Root Cause		FAULT CATEGORY							
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Other/Details:									



Remote Cargo Hook Test Form

C3

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 194630Customer LS552Serial Number 5186777Date 2019-7-2

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	Pass
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	Pass
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A <u>9.0</u>	A	Pass
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.8</u>	A	Pass
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.9</u>	A	Pass
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.2</u>	A	Pass
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.4</u>	A	Pass
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A <u>7.7</u>	A	Pass
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A <u>10.9</u>	A	Pass
1	3,000	Manual		N/A	Pass
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	Pass
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω <u>1.8</u>	Ω	Pass
1	N/A	Electircal Continuity	Across both wires	N/A	Pass

Test Conducted By: Michel Lalonde
TechnicianSignature: Sylvie Bonner
QC5 Small FAB / QA

Submit